

Work Order ID 84003 - 1

\*84003\*

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May-01-12 10:38:15 AM

Item ID: D119-675-012

Accept

\*N9000040100\*

Setup Start

\*NS1\*

Revision ID:

split (1x)

Stop \*NS2\*

Item Name: Heli-Access-Step RH

Start Date: 01/05/2012 Start Qty: 4.00

\*4\*

Cust Item ID:

Required Date: 15/05/2012 Req'd Qty: 4.00

\*4\*

Customer:

Reference:

Run Start \*NR1\*

Approvals: Process Plan: MJS

Date: 12/05/01 Tooling:

Date:

Stop \*NR2\*

QC:

Date: SPC (Y/N):

Date:

| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

Draw Nbr

Revision Nbr

N/A

Rev N/A

100

0.00

\*100\*

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP 119-675-012 CHG004

5/12/06/15 JB

110

Pick Kit

0.00

\*110\*

Packaging

Memo

0.00

Packaging

4

12/06/15 JA

120

QC4- 100% Inspect kits for completeness

0.00

\*120\*

QC

Memo

0.00

Quality Control

5/12/06/15

7/24

# Work Order ID 84003

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\*84003\*

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Item ID: D119-675-012

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Item Name: Heli-Access-Step RH

Stop \*NS2\*

Start Date: 01/05/2012 Start Qty: 4.00

\*4\*

Cust Item ID:

Required Date: 15/05/2012 Req'd Qty: 4.00

\*4\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

\*130\*

Packaging

Packaging

0.00

Memo

0.00

Identify and pack for shipping as per PPP D119-675-012

Location: FG

u 12-06-15

140

\*140\*

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

MLC 12/06/15

u 12-06-15



# Picklist Print

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Work Order ID: 84003

\*84003\*

Parent Item: D119-675-012

\*D119-675-012\*

Parent Item Name: Heli-Access-Step RH

Start Date: 01/05/2012

Required Date: 15/05/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:D Removed Manufacturing JLM 05-11-01  
IPP Rev:E change to rev.b as per ECN1107 DD verified by:

| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Qty per Kit | Total<br>Qty | Qty<br>Issued | Date<br>Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

D3043-042

Manufactured

No

110

Each

0.0000

1

4

\*\*

\*D3043-042\*

Step Weldment RH, A119

D2182B032

Manufactured

No

110

Each

14.0000

4

16

\*\*

\*D2182B032\*

Rubber Cushion

Location

Loc Qty

Loc Code

ST402

14

63469

4

73932

10

110

Each

632.0000

8

32

\*\*

D2274

Manufactured

No

\*D2274\*

Radius Block

Location

Loc Qty

Loc Code

ST007

632

78233

22

81958

400

83258

210

110

Each

20.0000

4

16

\*\*

D2617-3

Manufactured

No

\*D2617-3\*

Bushing

Location

Loc Qty

Loc Code

FG

10

27991

10

ST012

10

76948

10

84008

12/06/15



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Work Order ID: 84003

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Parent Item: D119-675-012

\*D119-675-012\*

Parent Item Name: Heli-Access-Step RH

Start Date: 01/05/2012

Required Date: 15/05/2012

Start Qty: 4.00

Required Qty: 4.00

D2617-5

Manufactured No

110 Each

21.0000

8

32

\*D2617-5\*

Spacer

\*\* 22X 84009



Location

Loc Qty

Loc Code

FG

10

31756

10

ST012

11

81814

11

10X 81814

D2732-032

Manufactured No

110 Each

0.0000

1

4

\*D2732-032\*

RUBBER CUSHION

D3041-1

Manufactured No

110 Each

23.0000

4

16

\*D3041-1\*

Clamp

\*\* 70787 JB

\*\* JB

Location

Loc Qty

Loc Code

ST462

23

77050

1

79723

22

1X 77050

0X 79723

D3041-3

Manufactured No

110 Each

24.0000

2

8

\*D3041-3\*

Clamp

\*\* JB

Location

Loc Qty

Loc Code

ST462

24

51114

8

76997

16

76697

D3042-1

Manufactured No

110 Each

20.0000

4

16

\*D3042-1\*

Clamp

\*\* 12X 83999

12/06/12

Location

Loc Qty

Loc Code

ST457

20

77487

20

4X 77487

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Shop Packet Print

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\*84003\*

Parent Item: D119-675-012

\*D119-675-012\*

Parent Item Name: Heli-Access-Step RH

Start Date: 01/05/2012

Required Date: 15/05/2012

Start Qty: 4.00

Required Qty: 4.00

AN4-11A  
\*AN4-11A\*  
Bolt

Purchased No

110 Each 244.0000 4 16

\*\*

## Location

## Loc Qty

## Loc Code

ST356

244

118706

94

120731

100

121243

50

118706

AN4-12A  
\*AN4-12A\*  
Bolt

Purchased No

110 Each 667.0000 8 32

\*\*

## Location

## Loc Qty

## Loc Code

ST357

667

115422

4

119775

50

120423

588

121524

25

120423

AN4-15A  
\*AN4-15A\*  
Bolt

Purchased No

110 Each 539.0000 4 16

\*\*

## Location

## Loc Qty

## Loc Code

GA

100

120449

100

ST358

439

118706

3

119449

1

119749

19

120422

116

121444

100

121541

200

121541



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Work Order ID: 84003

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Parent Item: D119-675-012

\*D119-675-012\*

Parent Item Name: Heli-Access-Step RH

Start Date: 01/05/2012

Required Date: 15/05/2012

Start Qty: 4.00

Required Qty: 4.00

AN960JD416

NAS1149D0463J

Purchased

No

110

Each

30.0000

12

48

**\*AN960.ID416\***

Washer

\*\*

121912 JB

*[Handwritten signature]*

## Location

## Loc Qty

## Loc Code

ST351

30

116289

10

119097

20

MS21042L4

Purchased

No

110

Each

5,520.000

12

48

**\*MS21042L4\***

Nut

\*\*

JB

*[Handwritten signature]*

12/06/15

## Location

## Loc Qty

## Loc Code

ST300

5520

119075

520

121011

2000

121444

3000

121444

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Shop Packet Print

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## 4.0 WEIGHT AND BALANCE:

| Installation                                | Weight            | LATERAL               |                           | LONGITUDINAL       |                         |
|---|-------------------|-----------------------|---------------------------|--------------------|-------------------------|
|   |                   | Arm                   | Moment                    | Arm                | Moment                  |
| D119-675-011<br><i>HELI-ACCESS-STEP™</i> LH | 11.5 lb<br>5.2 kg | - 32.4 in<br>- 1.28 m | - 373 in-lb<br>- 6.7 m-kg | 121.3 in<br>3.08 m | 1395 in-lb<br>16.0 m-kg |
| D119-675-012<br><i>HELI-ACCESS-STEP™</i> RH | 11.5 lb<br>5.2 kg | +32.4 in<br>+1.28 m   | +373 in-lb<br>+6.7 m-kg   | 121.3 in<br>3.08 m | 1395 in-lb<br>16.0 m-kg |

## 5.0 PARTS LIST:

| Qty<br>-011 | Qty<br>-012 | Part Number  | Description                 |
|-------------|-------------|--------------|-----------------------------|
| X           |             | D119-675-011 | <i>HELI-ACCESS-STEP™</i> LH |
|             | X           | D119-675-012 | <i>HELI-ACCESS-STEP™</i> RH |
| 4           | 4           | D2182B032    | RUBBER CUSHION              |
| 8           | 8           | D2274        | RADIUS BLOCK                |
| 4           | 4           | D2617-3      | BUSHING                     |
| 8           | 8           | D2617-5      | BUSHING                     |
| 4           | 4           | D2732-032    | RUBBER CUSHION              |
| 4           | 4           | D3041-1      | CLAMP                       |
| 2           | 2           | D3041-3      | CLAMP                       |
| 4           | 4           | D3042-1      | CLAMP                       |
| 1           |             | D3043-041    | STEP WELDMENT LH            |
|             | 1           | D3043-042    | STEP WELDMENT RH            |
| 4           | 4           | AN4-15A      | BOLT                        |
| 4           | 4           | AN4-11A      | BOLT                        |
| 8           | 8           | AN4-12A      | BOLT                        |
| 12          | 12          | AN960JD416   | WASHER                      |
| 12          | 12          | MS21042L4    | NUT (OR MS21042-4)          |

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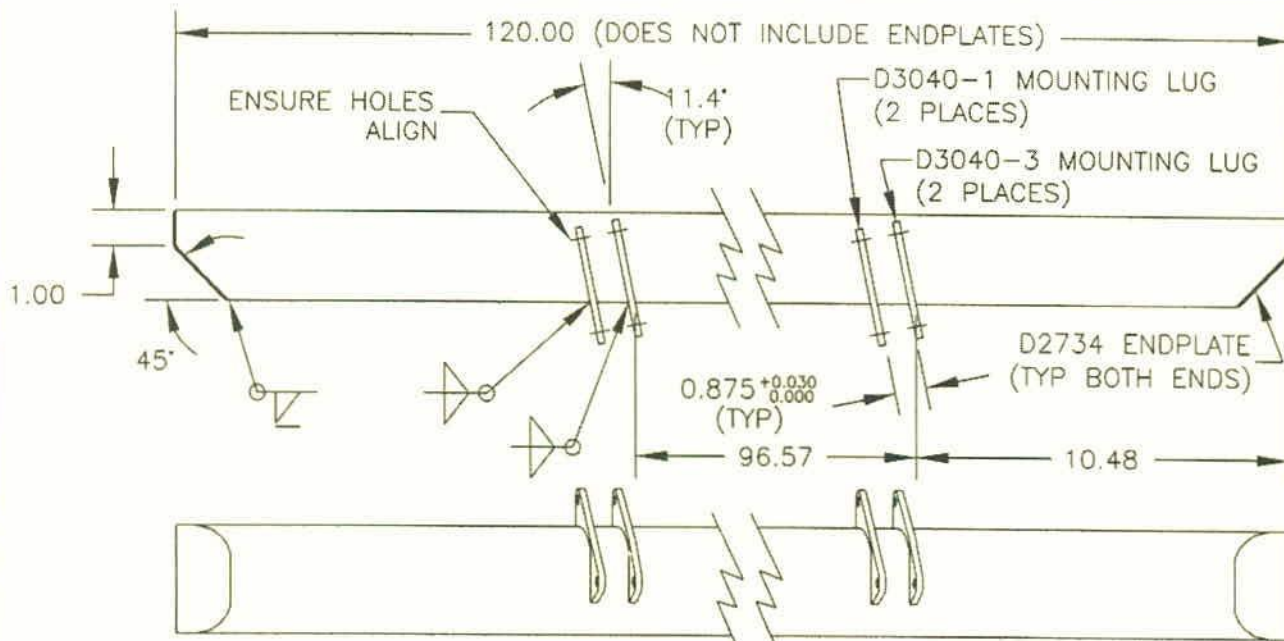
Revision: 8

Date: 07.10.23

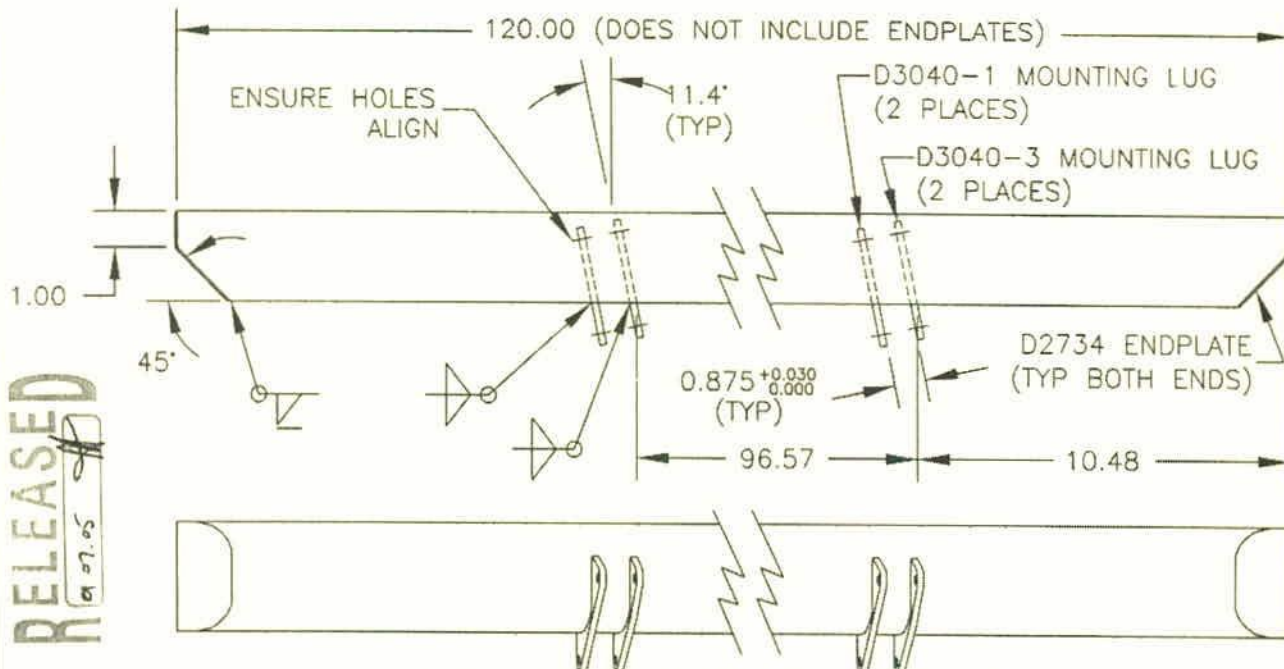


**DART**

|                  |                |  |                        |
|------------------|----------------|--|------------------------|
| DESIGN<br>CP     | DRAWN BY<br>CP | DART AEROSPACE USA, INC.<br>PORT HADLOCK, WA |                        |
| CHECKED<br>H     | APPROVED<br>H  | DRAWING NO.<br>D3043                         | REV. A<br>SHEET 2 OF 2 |
| DATE<br>01.06.28 |                | TITLE<br>A119 STEP WELDMENT                  | SCALE<br>1:5           |
| A                | 01.06.28       | NEW ISSUE                                    |                        |



VIEW A-A: D3043-041 LH STEP WELDMENT



VIEW A-A: D3043-042 RH STEP WELDMENT

RELEASED  
01.07.05

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